

BEST AVAILABLE COPY



Replacement Sheet 1
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

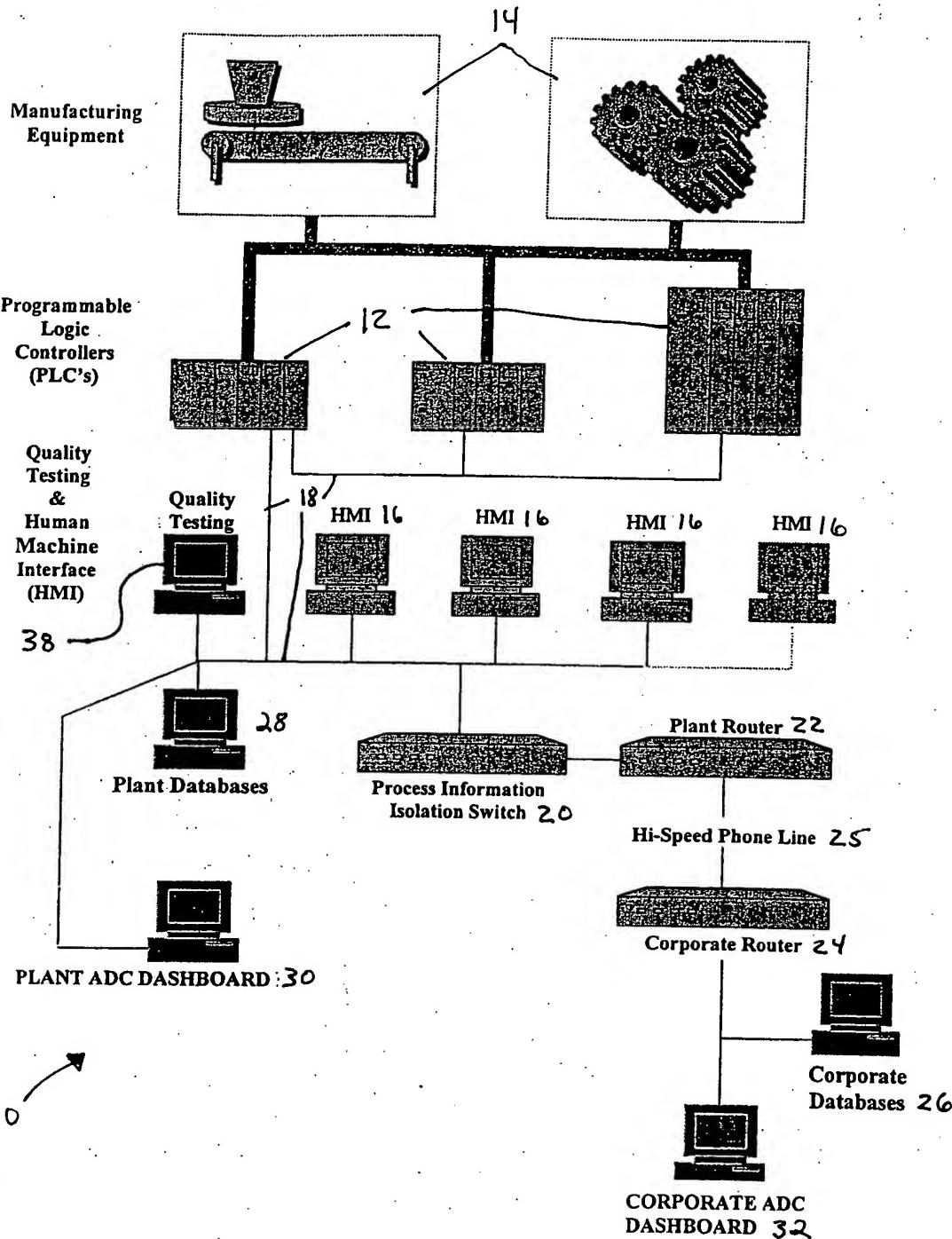


Fig. 1

Replacement Sheet 2
Serial No.: 10/828,751
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Inventors: Price, et al.

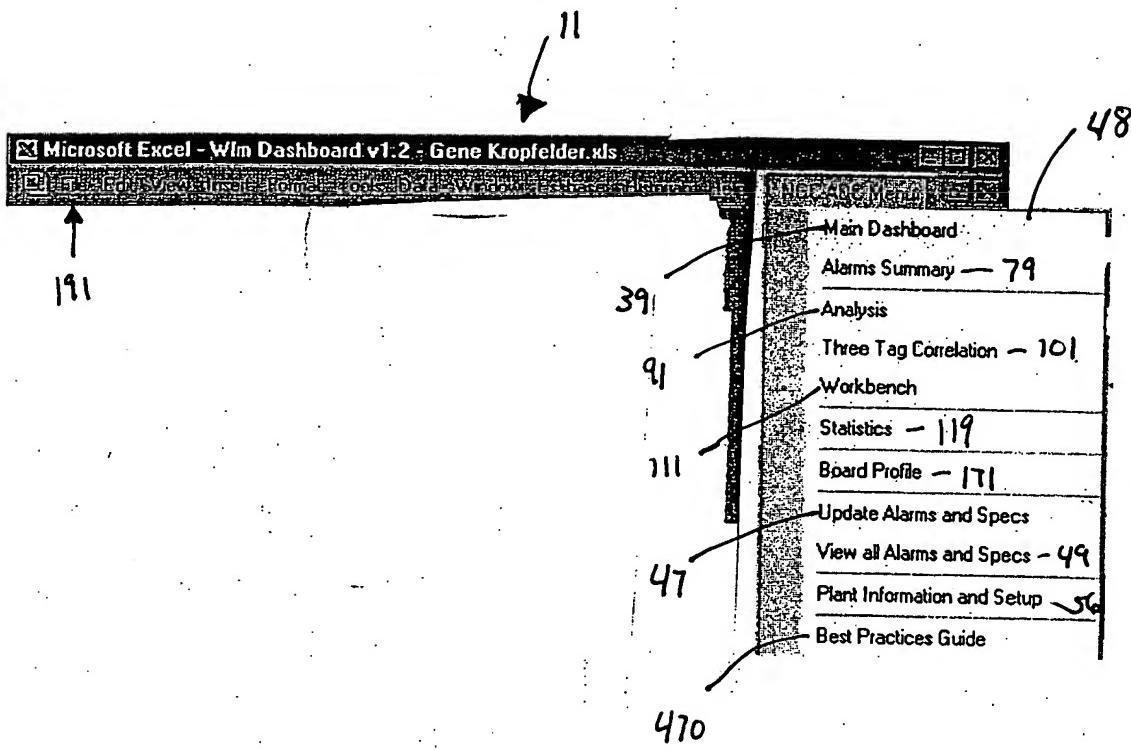


Figure 2a

Replacement Sheet 3
 Serial No.: 10/828,751
 Title: System and Method for Plant Management
 Inventors: Price, et al.

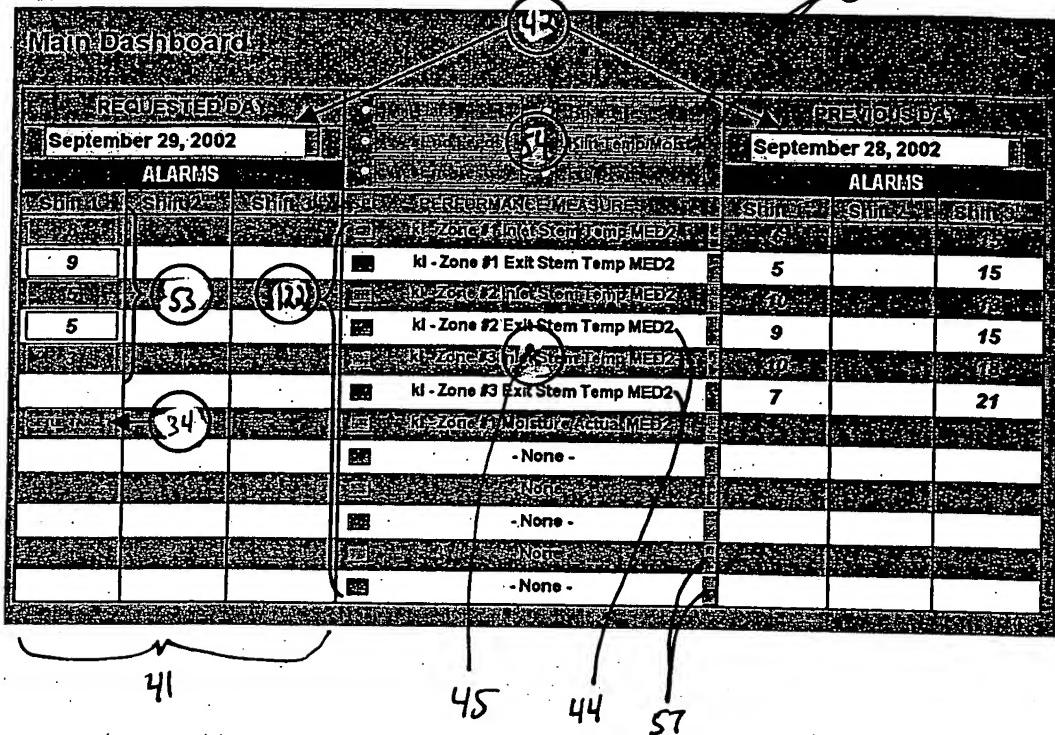


Fig. 2b

Replacement Sheet 4
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

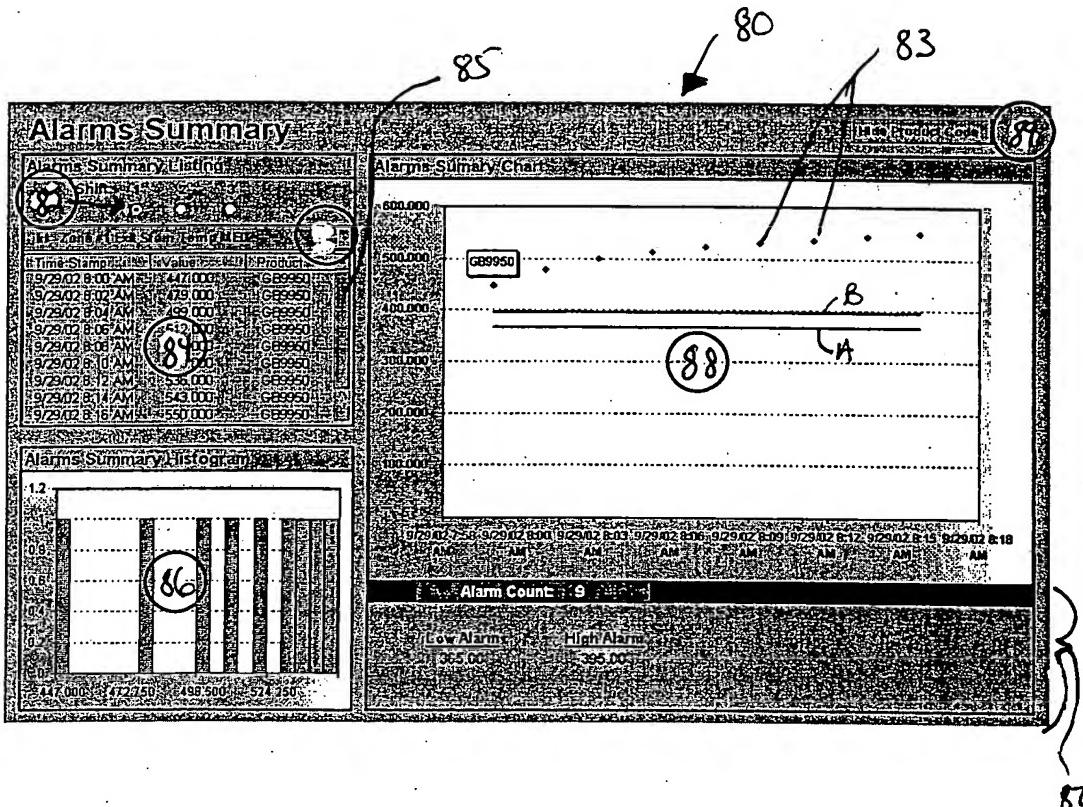


Fig. 3

Replacement Sheet 5
Serial No.: 10/828,751
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Inventors: Price, et al.

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Update Alarms and Specifications															
<input type="button" value="UPDATE"/>		<input type="button" value="SELECT FROM..."/> 54		<input type="button" value="ADD"/>		<input type="button" value="DELETE"/>		<input type="button" value="CHANGE"/>		<input type="button" value="HOME"/>		<input type="button" value="QUIT"/>			
<input type="button" value="CANCEL"/>															
Select Measure In															
m1 - Calcine #6 Outlet Temp Actual 50															
PLC Value	All	1	2	3	4	5	6	7	8	9	10	11	12	13	
Product Description	122-SS- 122-HS- 122-SM- 122-SM Smooth														
Product Code	All	GB4080	GB8019	GB6270	GB8116	GB2280	GB5926	GB6793	GB6601	GB6058	GB9950	GB1280	GB1310		
High Alarm	370	370	370	370	370	370	370	370	370	370	370	370	370		
Low Alarm	330	330	330	330	330	330	330	330	330	330	330	330	330		
Upper Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0		
Lower Spec Limit	0	0	0	0	0	0	0	0	0	0	0	0	0		

Fig. 49

Replacement Sheet 6
Serial No.: 10/828,751
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Microsoft Excel - \Vm\Dashboard v1.2 - Gene Kromfelder.xls															
	All	1	2	3	4	5	6	7	8	9	10	11	12	13	14
Row for Last Tag	PLC Value	All	1/2" TE	1/2" KK	1/2" FSQ	1/2" MR	1/2" KKFS	HS CELULITA	SMCR SHEATH	5/8" FS	5/8" MR	5/8" I/O	F554677SJS		
125	Product Description	All	GB3590	GB4080	GB5620	GB6793	GB3760	GB1242	GB0019	GB6270	GB8000	GB9550	GB1400	GB1050	GB9465
wlmBL_Line_Speed_Actual	High Alarm	190	190	190	190	190	190	190	190	190	190	190	190	190	190
	Low Alarm	140	140	140	140	140	140	140	140	140	140	140	140	140	140
	Upper Spec Limit														
	Lower Spec Limit														
wlmWE_Soap_Actual	Retrieval Interval														
	High Alarm	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8	0.8
	Low Alarm	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45	0.45
	Upper Spec Limit														
	Lower Spec Limit														
wlmWE_Stucco_Temp	Retrieval Interval														
	High Alarm	220	220	220	220	220	220	220	220	220	220	220	220	220	220
	Low Alarm	190	190	190	190	190	190	190	190	190	190	190	190	190	190
	Upper Spec Limit														
	Lower Spec Limit														
wlmK7_Ramsey_Weight_Actual	Retrieval Interval														
	High Alarm	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600	2600
	Low Alarm	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300	2300
	Upper Spec Limit														
	Lower Spec Limit														
wlmWE_Gauging_Water_Actual	Retrieval Interval														
	High Alarm	620	620	620	620	620	620	620	620	620	620	620	620	620	620
	Low Alarm	400	400	400	400	400	400	400	400	400	400	400	400	400	400
	Upper Spec Limit														
	Lower Spec Limit														
wlmDE_Moisture_Average	Retrieval Interval														
	High Alarm	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5	16.5
	Low Alarm	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5	12.5
	Upper Spec Limit														
	Lower Spec Limit														
wlmRD_Pan_Feeder_Rate_Actual	Retrieval Interval														
	High Alarm	55	55	55	55	55	55	55	55	55	55	55	55	55	55
	Low Alarm	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	Upper Spec Limit														
	Lower Spec Limit														
wlmRD_Moisture_Actual	Retrieval Interval														
	High Alarm	77	77	77	77	77	77	77	77	77	77	77	77	77	77
	Low Alarm	72	72	72	72	72	72	72	72	72	72	72	72	72	72
	Upper Spec Limit														
	Lower Spec Limit														

Fig. 46

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Replacement Sheet 7
Serial No.: 10/828,751
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Product Information				Shift Information			
PLC Value	Product Code	Product Description	Run Time	With Knives	Start Time	End Time	Comments
0	NONE	NO PRODUCT RUNNING		NONE	8:00 AM	4:00 PM	
2	GB0019	1/2" HS TE		48	10:00 AM	4:00 PM	
4	GB0116	1/2" SS HS (Sta-Smooth)		48	12:00 PM	4:00 PM	
6	GB5926	1/2" DB (Durabase)		48	2:00 AM	8:00 AM	
8	GB6601	1/2" FSC SS (Sta-Smooth)		48			
10	GB9950	5/8" FS TE		48			
12	GB1310	5/8" FS SS		48			
14							
16							
18							
20							
22							
24							

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 ↘ 60

70 |
 | 66 |
 | 64 |
 | | 68 |

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Plant Information			
Line Length (Mix to Knife) - Feet	595	Wet Transfer Length - Feet	300
Kiln Length - Feet	413	Number of Decks (N)	
Kiln Zone 1 Length - Feet	121	Kiln Zone 2 Length - Feet	102
Kiln Zone 3 Length - Feet	205	Kiln Zone 4 Length - Feet	

fig. 5

Replacement Sheet 8
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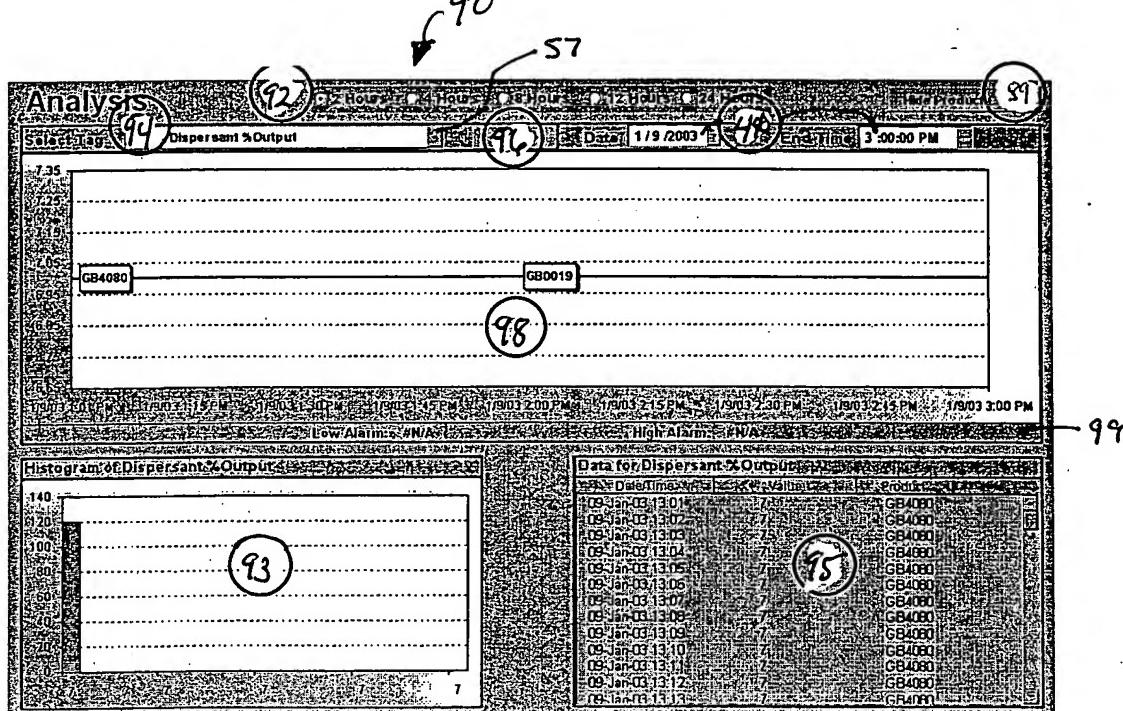


Fig. 6

*Replacement Sheet 9
Serial No.: 10/828,751
Title: System and Method for Plant Management
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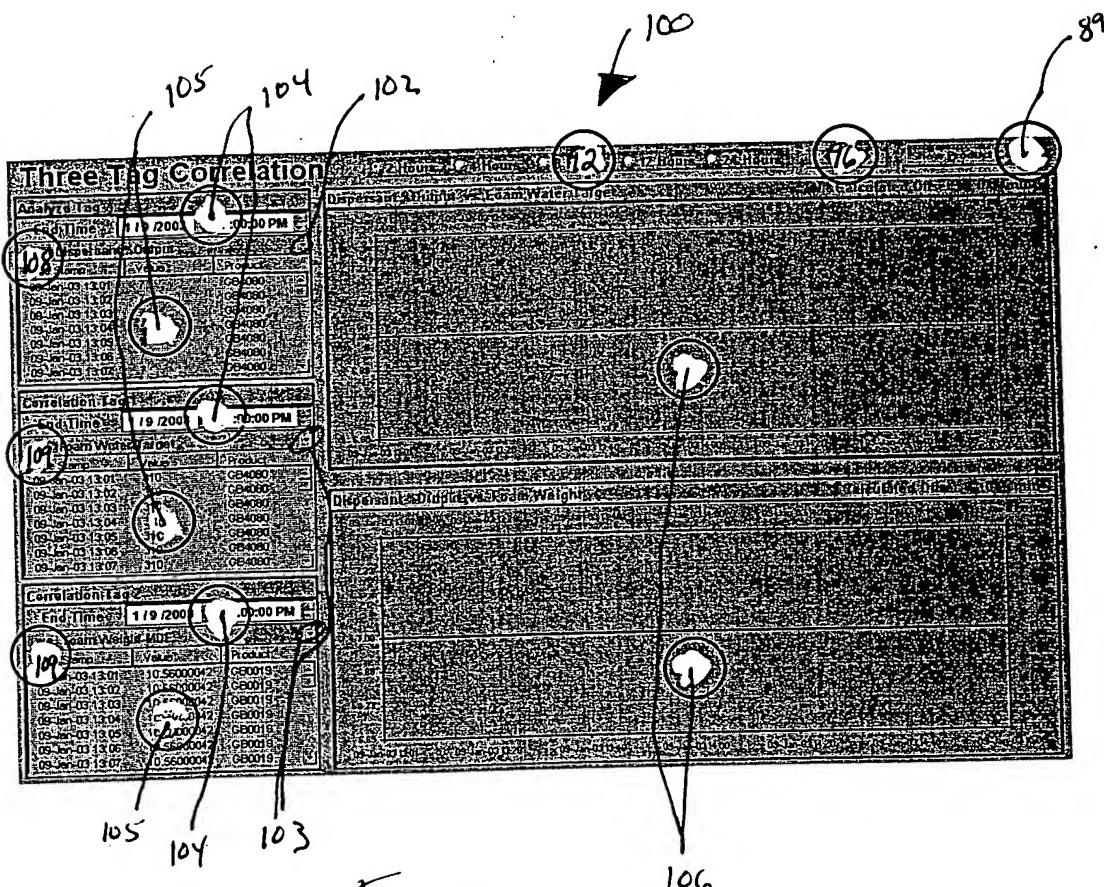


Fig. 7

Replacement Sheet 10

Serial No.: 10/828,751

Title: System and Method for Plant Management

Inventors: Price, et al.

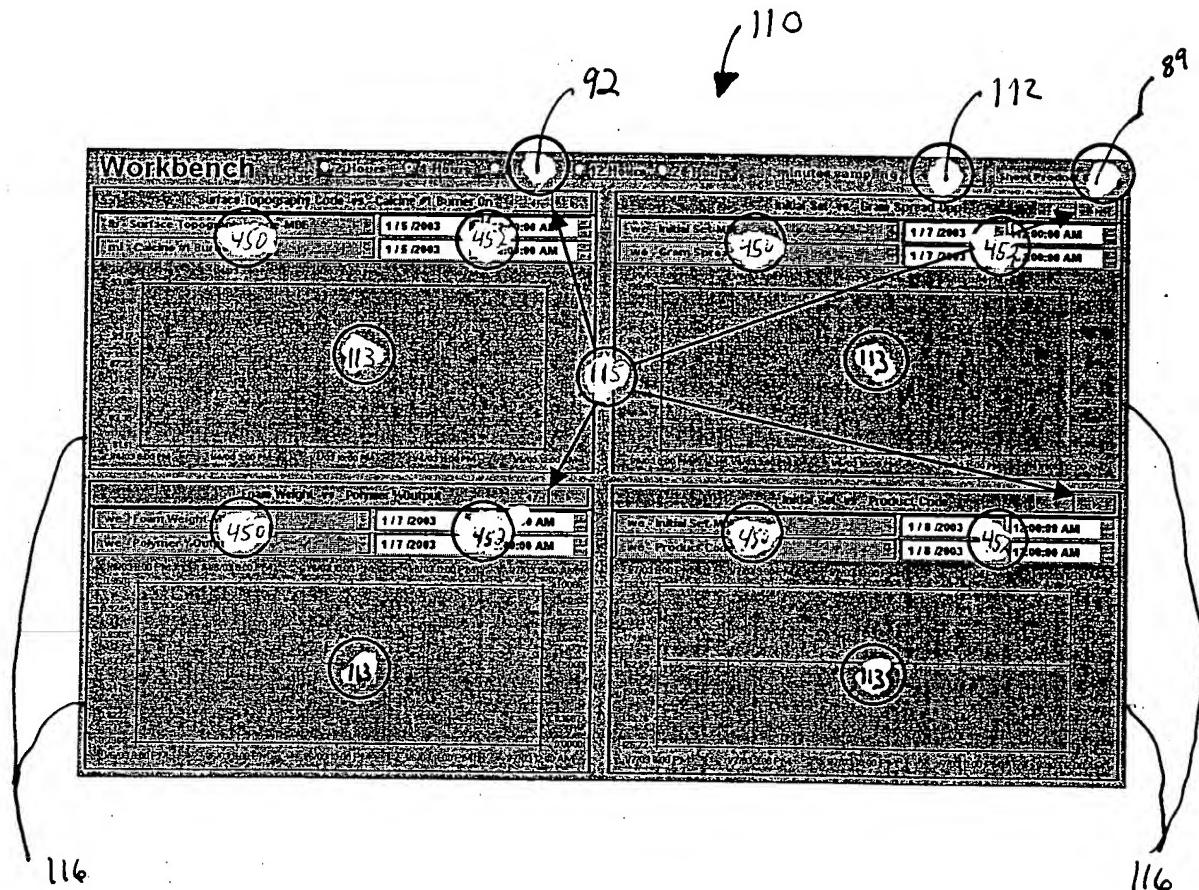


Fig. 8

Replacement Sheet 11

Serial No.: 10/828,751

*Title: System and Method for Plant Management
Inventors: Price, et al.*

Fig. 9

Replacement Sheet 12
 Serial No.: 10/828,751
 Title: System and Method for Plant Management
 Inventors: Price, et al.

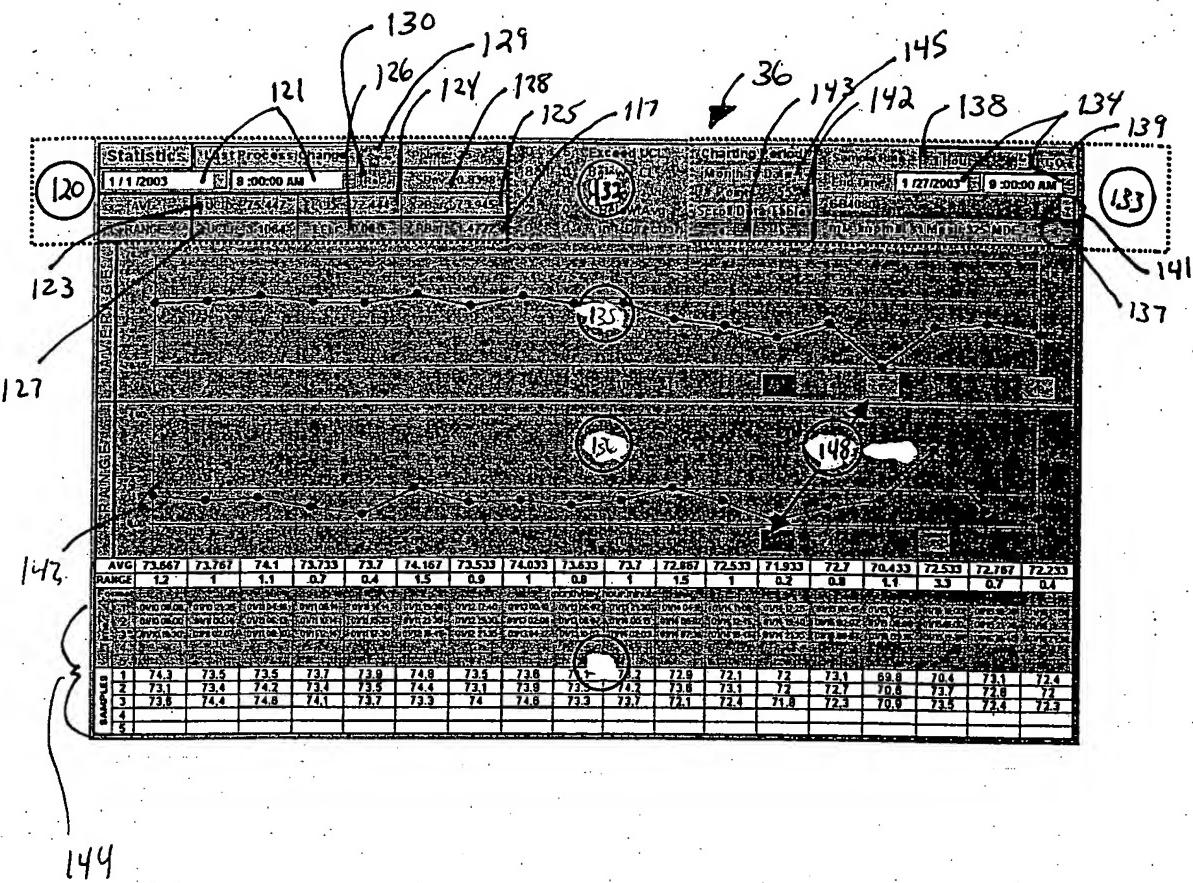


Fig. 10

Replacement Sheet 13
Serial No.: 10/828,751
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Inventors: Price, et al.

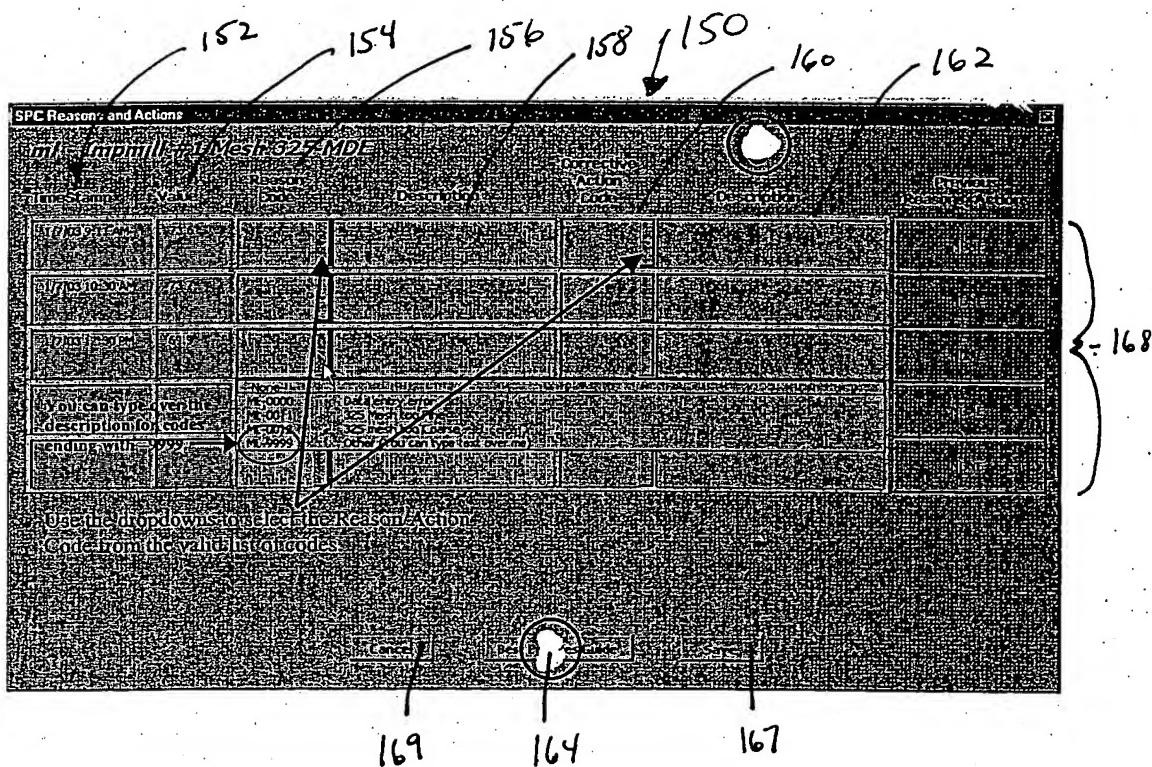


Fig. 11c

Replacement Sheet 14
Serial No.: 10/828,751
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Inventors: Price, et al.

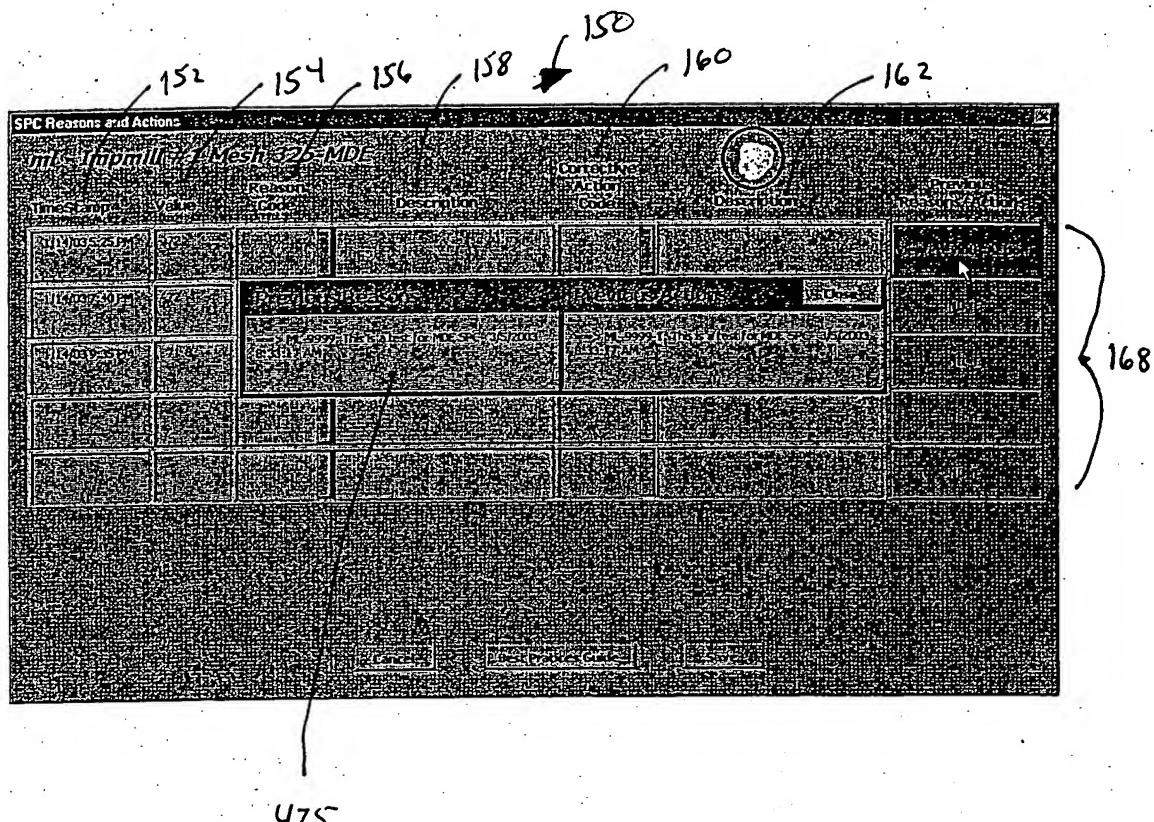


Fig. 11b

The goal of this SOP is to produce stucco that is calcined below theoretical with as few adjustments as possible.

BEST PRACTICE/S.O.P.

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1. Combined water of stucco exceeds the upper limit.

Make sure the grinds are in the reasonable limits.
(Course grounds will cause the moistures to go up)

Examine the history of previous moisture's.
(2 samples in a row high or most of the samples were high)

Examine the purity.
(If the purity went up quite a bit, the moisture's will get higher)

If grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the upper limits then an adjustment to the calcidyne needs to be made.

When the purity goes up, it may take some time for the calcidyne's to adjust, no need to make adjustments right away. Run a couple of samples and see if they will adjust by themselves. If not make an adjustment.

2. Combined water of stucco is less than the lower limit

Make sure the grinds are in the reasonable limits.
(Fine grinds will cause the moistures to go down)

Examine the history of previous moisture's.
(2 samples in a row low or most of the samples were low)

Examine the purity.
(If the purity went down quite a bit, the moisture's will get lower).

If grinds are out of the control limits, they need to be lined out before any adjustments are made to the calcidyne's.

If grinds are in the control limits and purity is stable and sample still exceeds the lower limits then an adjustment to the calcidyne needs to be made.

*Replacement Sheet 16
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Quality Report Login Screen

Open File 194

Enter Password Enter Password 181

Select Plant Apollo Beach 195

Select Server Corporate 197

The Selected Server Is:
HQADC

199

Required to Change Plant Server

Required to Activate the Open File Button of a Computer User

Select Plant Only if you are at the plant

Select Corporate only if you are located in Charlotte, or you need to access a plant server other than your own

Fig. 13

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MONTHLY BOARD QUALITY REPORT

Select Plant and Date For Report

Selected Plant: 185 Wilmington

Select Month & Year: 2002 December

Start Date: 17/11/2002

End Date: 27/11/2002

Select Products To Include In This Report

Product 1: 1/2" HS CEILING

Product 2: 1/2" MR

Product 3: 1/2" TE

Product 4: 1/2" FSG

Product 5: 5/8" FS

Server In Use: 194 HQADCE

Selected Server: 197 Corporate

187

199 → 206

210

213 → 201

215

View Product Detail

View / Print Reports

Retrieve Data

Setup

Data must be retrieved before you view Product Details or Reports

Review and Update Product Information

Monthly Board Quality Report

Fig. 14

MONTHLY BOARD QUALITY REPORT

F 200

PRODUCT CODE AND DESCRIPTION	GB4080 1/2 REG-TE	GB9950 1/2 FS TE	GB2280 1/2 KK-TE	GB0019 1/2 HS TE	GB0116 1/2 SS HS (Smooth)
NAIL PULL (lbs. of force)					
Number of samples	75	22	1	9	4
Specification (Min)	80.0	90.0	80.0	80.0	80.0
3-Month Rolling Average	71.4	84.8	82.1	70.6	70.9
Standard Deviation	2.722	4.458		2.985	3.081
Year-to-Date Average	71.4	84.8	82.1	70.6	70.9
Prior Year Average	74.886	89.838	85.750	77.067	76.100
Cpk	-0.049	-0.391		-1.046	-0.990
Est. Defects Per 1,000 Units	> 500	> 500		> 500	> 500
Cp	-0.049	-0.391		-1.046	-0.990
CORE HARDNESS (lbs. of force)					
Number of samples	68	21	1	9	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	17.1	23.0	19.3	17.1	16.3
Standard Deviation	1.366	1.750		1.054	0.831
Year-to-Date Average	17.1	23.0	19.3	17.1	16.3
Prior Year Average	18.276	23.056	17.333	18.389	16.889
Cpk	0.518	1.514		0.668	0.535
Est. Defects Per 1,000 Units	80	< 1		40	80
Cp	0.518	1.514		0.668	0.535
EDGE HARDNESS (CODE) (lbs. of force)					
Number of samples	67	21	1	8	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	56.1	72.4	64.3	56.5	51.7
Standard Deviation	4.725	9.285		6.644	7.193
Year-to-Date Average	56.1	72.4	64.3	56.5	51.7
Prior Year Average	42.430	64.194	55.000	43.846	47.000
Cpk	2.900	2.061		2.080	1.703
Est. Defects Per 1,000 Units	< 1	< 1		< 1	< 1
Cp	2.900	2.061		2.080	1.703
EDGE HARDNESS (OPP/CODE) (lbs. of force)					
Number of samples	66	21	1	8	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	62.1	75.0	79.3	57.7	62.7
Standard Deviation	5.351	7.700		4.366	0.837
Year-to-Date Average	62.1	75.0	79.3	57.7	62.7
Prior Year Average	49.159	60.030	62.222	46.282	47.000
Cpk	2.934	2.599		3.261	19.016
Est. Defects Per 1,000 Units	< 1	< 1		< 1	< 1
Cp	2.934	2.599		3.261	19.016
END HARDNESS (lbs. of force)					
Number of samples	69	21	1	9	4
Specification (Min)	15.0	15.0	15.0	15.0	15.0
3-Month Rolling Average	16.1	22.2	20.3	16.4	15.2
Standard Deviation	1.385	1.798		0.961	0.638
Year-to-Date Average	16.1	22.2	20.3	16.4	15.2
Prior Year Average	17.829	22.528	18.000	18.028	16.889
Cpk	0.255	1.336		0.488	0.087
Est. Defects Per 1,000 Units	300	< 1		120	> 500
Cp	0.255	1.336		0.488	0.087

Fig. 15

Replacement Sheet 19
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

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Return

Monthly Board Weight Report

PLANT: Wilmington

MONTH: February 2003

Save As File

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1/2" SHEATHING		MONTHLY WEIGHT DATA		
Board		Avg. Weight	Std. Dev.	No. of Samples
December 2002		1719	9	2
January 2003		1713	16	6
February 2003				
March 2003				
April 2003				
May 2003				
June 2003				
JULY 2003				
August 2003				
September 2003				
October 2003				
November 2003				
December 2003				
YTD AVERAGE		1713	16	6

Fig. 16

Replacement Sheet 20
Serial No.: 10/828,751
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Product Data

PLC Value	Description	Product Code	Width	STD Speed	STD Dry Weight	STD Water Loss	STD - 2-Hr Humidified Bond	STD - 20-Hr Humidified Bond	Go Live Date
0	NO PRODUCT RUNNING	None	NA	NA	NA	NA	NA	NA	6/1/02 12:00 AM
1	3/8" TE	GB3950	48"	NA	NA	NA	NA	NA	
105	1/2" TE 406	GB1050	48"	NA	NA	NA	NA	NA	
1	1/2" KR	GB5620	48"	NA	NA	NA	NA	NA	
4	1/2" FSG	GB6793	48"	NA	NA	NA	NA	NA	
5	1/2" MR	GB3760	48"	NA	NA	NA	NA	NA	
6	1/2" KK FS	GB1242	48"	NA	NA	NA	NA	NA	
7	1/2" HS CEILING	GB0019	48"	NA	NA	NA	NA	NA	
8	1/2" SS (STA SMOOTH)	GB6270	48"	NA	NA	NA	NA	NA	
9	1/2" SHEATHING	GB8000	48"	NA	NA	NA	NA	NA	
10	5/8" FS	GB9950	48"	NA	NA	NA	NA	NA	
11	5/8" MR FS	GB1400	48"	NA	NA	NA	NA	NA	
12	5/8" KK FS	GB1050	48"	NA	NA	NA	NA	NA	
13	5/8" FS JS	GB9466	48"	NA	NA	NA	NA	NA	
14				NA	NA	NA	NA	NA	
15				NA	NA	NA	NA	NA	
16				NA	NA	NA	NA	NA	
17				NA	NA	NA	NA	NA	
18				NA	NA	NA	NA	NA	
19				NA	NA	NA	NA	NA	
20				NA	NA	NA	NA	NA	
21				NA	NA	NA	NA	NA	
22				NA	NA	NA	NA	NA	
23				NA	NA	NA	NA	NA	

Return

Fig. 17

Replacement Sheet 21
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Inventors: Price, et al.

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1/2" TE GB4050												Transverse			
Return															
Date	Machine Speed	Dry Weight	Wet Weight	Water Loss	Board Width	Taper Depth			Edge Hardness			Face Up MD	Face Down		
						Code	Dry Code	Caliper	Core Hardness	Code	Dry Code				
January 2003															
Monthly Information															
Count	1339	272	273	26	272	270	271	272	25	3	3	0	3	9	25
January 2003	180.7	1714	2215	801	48.00	0.058	0.058	0.490	77.1	21.2	30.2	19.2	0.117	51	51
Daily Information															
January 1, 2003															
January 2, 2003															
January 3, 2003	181.8	1732	2505	773	48.00	0.055	0.056	0.491							
January 4, 2003	182.0	1713	2513	801	48.00	0.054	0.053	0.491	75.2						
January 5, 2003	180.2	1698	2468	770	48.00	0.049	0.054	0.491							
January 6, 2003	181.8	1718	2478	760	48.00	0.053	0.056	0.492	88.0						
January 7, 2003	181.7	1570	2241	790	48.00	0.049	0.059	0.490	74.4						
January 8, 2003	181.8	1718	2471	761	48.00	0.059	0.061	0.491	77.7						
January 9, 2003	181.8	1709	2411	762	48.00	0.052	0.060	0.495	74.0						
January 10, 2003															
January 11, 2003	180.7	1721	2441	765	48.00	0.054	0.053	0.487							
January 12, 2003	181.8	1716	2469	773	48.00	0.045	0.049	0.489	82.0						
January 13, 2003	182.1	1728	2518	769	47.99	0.054	0.056	0.490	78.7						
January 14, 2003	181.9	1715	2525	820	47.98	0.061	0.058	0.491	78.7	21.3	30.3	20.0	0.125	55	51
January 15, 2003	181.8	1713	2534	821	48.00	0.060	0.062	0.495							
January 16, 2003	177.2	1703	2505	802	48.00	0.063	0.062	0.489							
January 17, 2003	181.7	1734	2567	803	48.00	0.063	0.053	0.490	76.2						
January 18, 2003															
January 19, 2003	177.9	1709	2533	823	47.99	0.060	0.046	0.487							
January 20, 2003	182.1	1706	2504	798	48.00	0.053	0.048	0.490	78.9						
January 21, 2003	181.0	1709	2537	828	48.00	0.048	0.047	0.491	74.8						
January 22, 2003	179.0	1718	2553	836	48.00	0.052	0.055	0.489	79.2	21.0	30.0	18.3	0.094	50	49
January 23, 2003	180.9	1719	2535	815	47.99	0.055	0.062	0.492	81.0						
January 24, 2003	182.0	1725	2547	822	47.98	0.066	0.056	0.493	85.6						
January 25, 2003															
January 26, 2003	178.5	1722	2524	802	47.99	0.067	0.058	0.489	73.3						
January 27, 2003	182.0	1718	2515	797	48.00	0.055	0.065	0.488	70.6						
January 28, 2003	181.7	1715	2524	809	48.00	0.061	0.055	0.489	77.0						
January 29, 2003	181.8	1708	2541	833	47.99	0.059	0.061	0.491	68.8						
January 30, 2003	181.5	1713	2537	824	48.00	0.049	0.058	0.491							
January 31, 2003															

Fig. 18a

Replacement Sheet 22
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	Machine Speed	Dry Weight	Vet Weight	Water Loss	Board Width	Taper Depth				Edge Hardness				Transverse S		
					Code	Opp Code	Caliper	Nail Pull	Core Hardness	Code	Opp Code	d	Defects	Face Up MD		
February 2003																
3-Month Rolling Avg																
Average	180.8	2511	800	47.997	0.057	0.058	0.490	77.5	21.8	26.8		19.0	0.129	48	50	
Number of Samples	231	845	54	593	597	568	593	49	3	3	0	3	28	49	48	
LSL				47.29032	0.050	0.050	0.485	80	15.0	15.0	15.0	15.0		40	40	
USL				48	0.050	0.050	0.515									
Std Dev	3.484	35.867	49.956	33.603	0.018	0.020	0.017	0.001	4.367	1.072	2.411		0.982	0.078	4.442	3.550
Std Dev / 1.7321	2.000	31.967	26.533	19.400	0.009	0.011	0.010	0.002	2.533	0.819	1.392		0.509	0.014	2.564	2.050
Cpk					0.115	0.948	1.178	3.850								
Cpkd					3.230	0.217	0.222	0.829	-0.334	3.652	3.299					
Cpk					0.115	0.217	0.222	0.829	-0.334	3.652	3.299					
Cp					1.873	0.503	0.698	2.359	-0.334	3.652	3.299					
3-Month Period Ending																
January	181.1	1712	2509	798	48.00	0.058	0.058	0.490	77.5	21.8	26.8		19.0	0.129	48	50
February	180.6	2511	800	48.00	0.057	0.058	0.490	77.5	21.8	26.8		19.0	0.129	48	50	
March	179.9	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51	
April	177.0	2527	835	48.00	0.053	0.057	0.492									
May																
June																
July																
August																
September																
October																
November																
December																

Fig. 18 b

	Machine Speed	Dry Weight	Vet Weight	Water Loss	Board Width	Taper Depth				Edge Hardness				Transverse S		
					Code	Opp Code	Caliper	Nail Pull	Core Hardness	Code	Opp Code	d	Defects	Face Up MD		
Current Year Info																
Year-to-date Avg	178.9	1710	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51
Entire Year Avg	179.9	2517	807	48.00	0.058	0.057	0.491	77.1	21.2	30.2		19.2	0.117	51	51	
(422)																
December (Last Year)	181.5	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0		18.7	0.133	45	49	
January	180.7	1714	2515	801	48.00	0.058	0.058	0.490	77.1	21.2	30.2		19.2	0.117	51	51
February	177.0	1692	2527	835	48.00	0.053	0.057	0.492								
(423)																
Prior Year Info																
Overwrite Historian Data																
Enter Year Avg																
Historian Data																
Entire Year Avg	178.1	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0		18.7	0.133	45	49	
Year-to-date Avg	(422)															
Entire Year Avg	178.1	1747	2502	791	48.00	0.060	0.058	0.490	77.8	23.0	26.0		18.7	0.133	45	49
(424)																

Fig. 18c

Replacement Sheet 23
 Serial No.: 10/828,751
 Title: System and Method for Plant Management
 Inventors: Price, et al.

C:\Documents and Settings\gbccdp\Local Settings\Temporary Internet Files\OLK4\Documentation-Adhoc Reporting Tool.moc

Select Starting Date and Time:		Select Period / Frequency:		RETRIEVE DATA		SAVE TO FILE		Select Server						
February 25, 2003	12:00 AM	Apollo	1 Day - Every 15 Minutes					Corporate Server						
Previous	Next							For best performance: If you are at a plant, you should select Plant Server. Likewise, if you are in Charlotte, you should select Corporate Server.						
Select Measures		WE	KF	DE	KF	DE	KF	DE	KF	DE	DE	DE	DE	LB
DATA		WE Product Code	KF Product Code	DE Product Code	KF Weight	DE Weight	KF Width	DE Width	KF Caliper Analog	DE Caliper Analog	DE Caliper Edge Differential	DE End Pct Klin Differential	LB Humidif Front Face	LB Back
Average														
Standard Deviation														
Date / Time														
2/25/03 12:00 AM		Running	7.000											
2/25/03 12:15 AM		Running	7.000											
2/25/03 12:30 AM		Running	7.000											
2/25/03 12:45 AM		Running	7.000											
2/25/03 1:00 AM		Running	7.000											
2/25/03 1:15 AM		Running	7.000											
2/25/03 1:30 AM		Running	7.000											
2/25/03 1:45 AM		Running	7.000											
2/25/03 2:00 AM		Running	7.000											
2/25/03 2:15 AM		Running	7.000											
2/25/03 2:30 AM		Running	7.000											
2/25/03 2:45 AM		Running	7.000											
2/25/03 3:00 AM		Running	7.000											
2/25/03 3:15 AM		Running	7.000											
2/25/03 3:30 AM		Running	7.000											
2/25/03 3:45 AM		Running	7.000											
2/25/03 4:00 AM		Running	7.000											
2/25/03 4:15 AM		Running	7.000											
2/25/03 4:30 AM		Running	7.000											
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2/25/03 5:15 AM		Running	7.000											
2/25/03 5:30 AM		Running	7.000											
2/25/03 5:45 AM		Running	7.000											
2/25/03 6:00 AM		Running	7.000											

Fig. 19

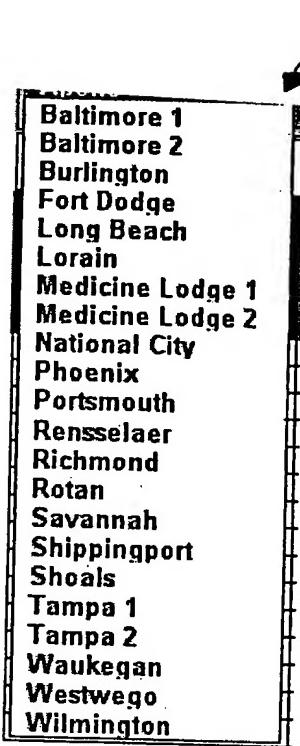
Select Starting Date and Time:		12:00 AM
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Replacement Sheet 25

Serial No.: 10/828,751

Title: System and Method for Plant Management

Inventors: Price, et al.



255

Baltimore 1
Baltimore 2
Burlington
Fort Dodge
Long Beach
Lorain
Medicine Lodge 1
Medicine Lodge 2
National City
Phoenix
Portsmouth
Rensselaer
Richmond
Rotan
Savannah
Shippingport
Shoals
Tampa 1
Tampa 2
Waukegan
Westwego
Wilmington

Fig. 206

Select Period / Frequency

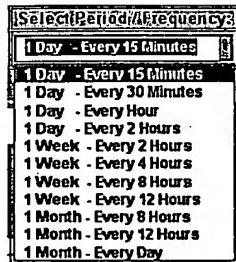


Fig. 20c

Select Server



Fig. 20d

Select Measures (Tags)

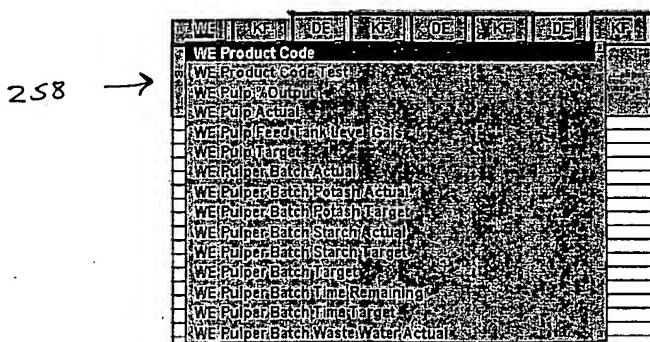


Fig. 20e

Replacement Sheet 27
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

Dry End Manual Data Entry

Plant Line	SHO 1	Product Code	GB4080	WHS#	2/2	Description	1/2" REG TE	Modulus	1000
Setup		Code Date	10/1/2002	Code Time	10 : 00	Spec. Prod. Qty	1000	Spec. Prod. Day	1000
Bears. Calib. Test					Averaging Test				
Edge Differentiation	X	Thickness of an edge	X	Opposite Edge Width	X	Spec. for Differentiation	X	Opposite Edge Width	X
Code Length Dev.	X	Thickness of an edge	X	Opposite Edge Angle	X	Spec. for Length Dev.	X	Opposite Edge Angle	X
Code Length Width	X	Opposite Edge Angle	X	Upper Edge Hardness	X	Spec. for Length Width	X	Upper Edge Hardness	X
Code Edge Angle	X	Upper Edge Hardness	X	Shim	X	Spec. for Edge Angle	X	Shim	X
Code Edge Hardness	X	Shim	X	Surface Appearance	X	Spec. for Edge Hardness	X	Surface Appearance	X
Code Edge Profile	X	Surface Appearance	X	Label Control	X	Spec. for Edge Profile	X	Label Control	X
Code Spills	X	Label Control	X	Squareness	X	Spec. for Spills	X	Squareness	X
Code Back	X	Squareness	X	Label Control	X	Spec. for Back	X	Label Control	X
X Inch	X	X mm	X	X mm	X	X Inch	X	X mm	X

313 311 300 305
308 310 306 314 307
315

Fig. 21

Replacement Sheet 28

Serial No.: 10/828,751

Title: System and Method for Plant Management

Inventors: Price, et al.

Fig. 22

Replacement Sheet 29
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

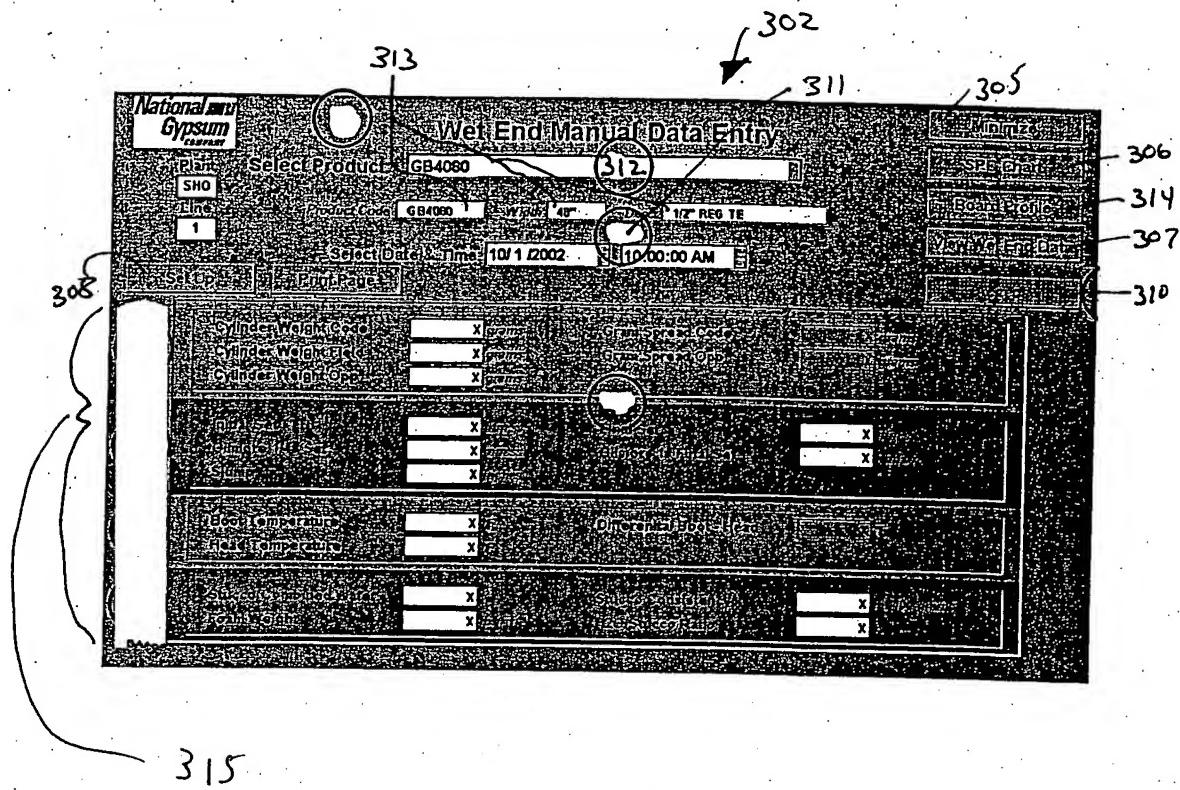


Fig. 23

Replacement Sheet 30
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

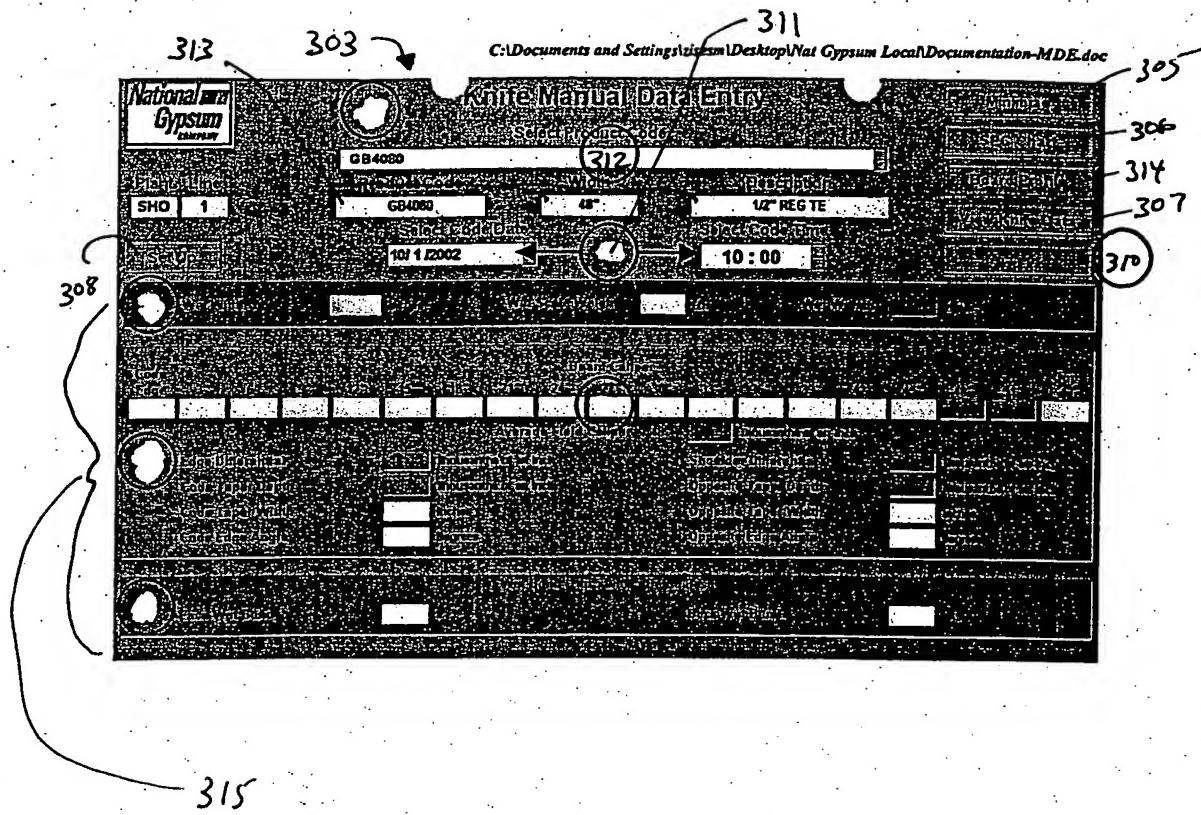


Fig. 24

Replacement Sheet 31
Serial No.: 10/828,751
Title: System and Method for Plant Management
Inventors: Price, et al.

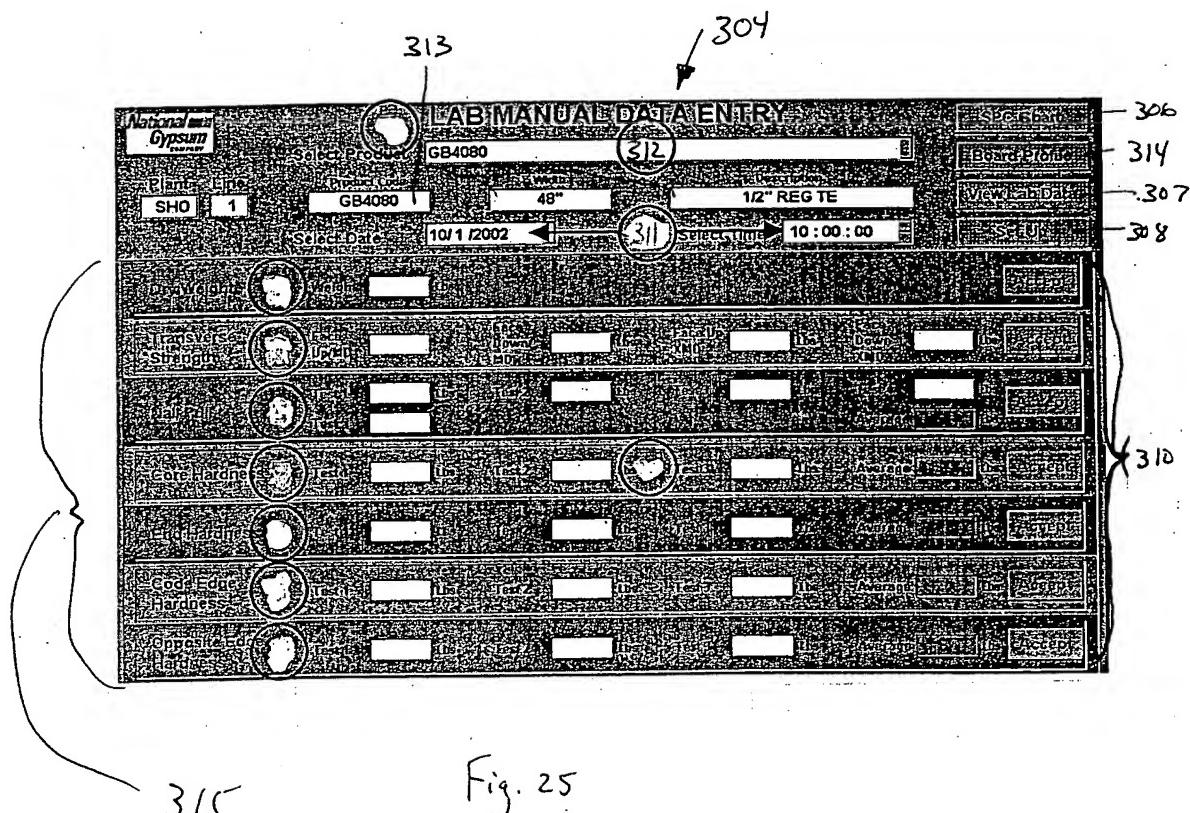


Fig. 25

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